

Date: Thursday, 19/03/2009 4:31:16 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE ASSEMBLY
Job Number	: 46622		
Estimate Number	: 13803		
P.O. Number	:	Part Number	: D3805047
This Issue	: 19/03/2009 S.O. No. :	Drawing Number	: D3805 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 31/03/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>JUD 09.03.09</u>		
Comment	: Est Rev:A 08-12-01 new issue EC verified by:DD Est Rev:B 09-03-04 rev.a as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D38057	Plate
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Plate

batch: B46788

EL 9-4-7

2.0	D38067	Bar
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bar

batch: B46787

EL 9-4-7 ds

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1- on D3806-7, fill cut outs with hardcoat welding rod as per dwg D3805

2059 B Hardcoat Welding Rod

BATCH#: M11036

2-weld D3806-7 to wearplate by positioning holes together as per dwg D3805

304 S.S. Welding Rod

BATCH #: M106115

EL 9-4-7 ds

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

Cpl 09.04.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 4:31:16 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE ASSEMBLY

Job Number: 46622

Part Number: D3805047

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/07 (x2)

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M1096478

START TIME:

1:30

OVEN TEMPERATURE:

320°

FINISH TIME:

2:00

BR 09-04-7

(2)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 09-04-07

8.0

D38077

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Gasket

batch:

B46780

FF 09-04-08

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bond D3807-7 gasket to inner surface of wearplate using Scotch-grip adhesive.

A/R Scotch-grip batch: M109410

FF 09-04-08

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/08 (x2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location:

Handing

Le 9/4/8 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 4:31:17 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE ASSEMBLY

Job Number: 46622

Part Number: D3805047

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

209/04/09

Job Completion



mf

09-04-09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

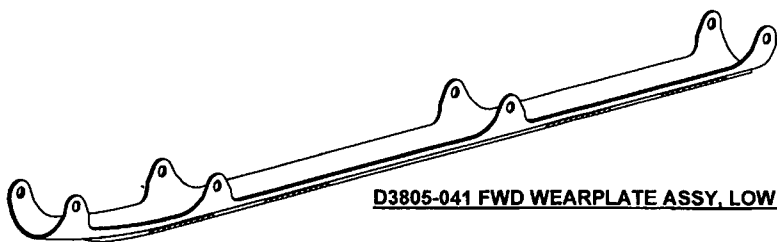
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

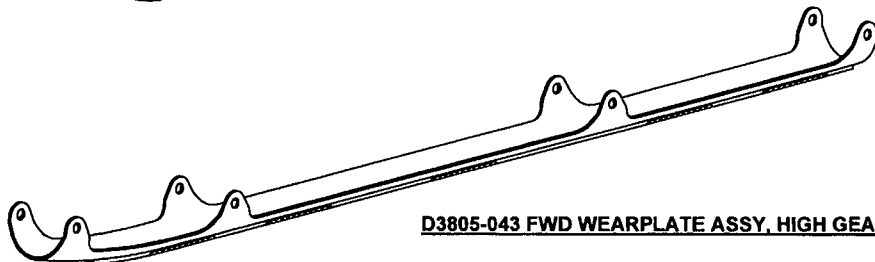
NOTE: Date & initial all entries

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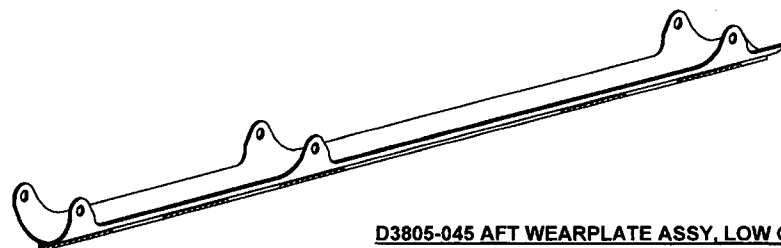
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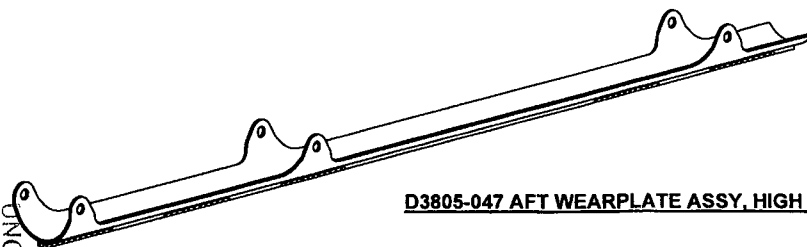
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

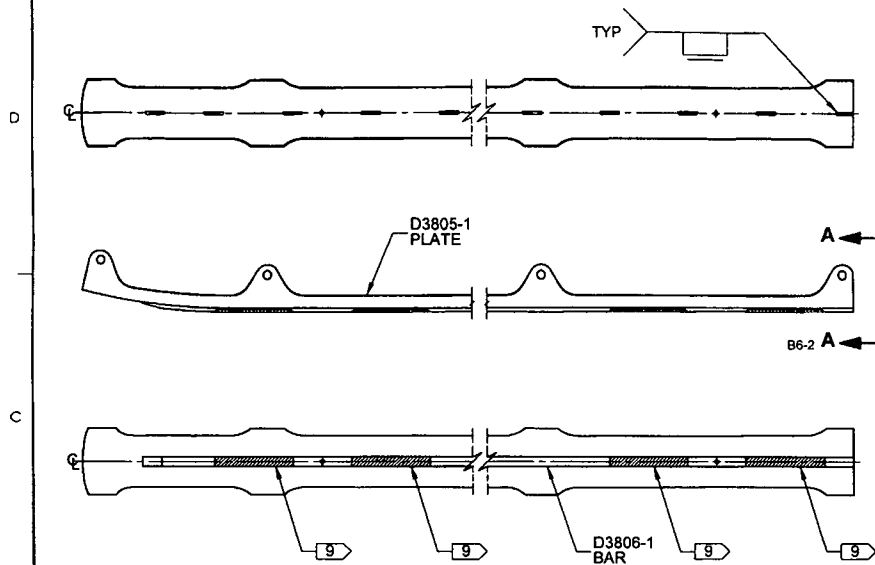
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 47 07.03.03
 PER ECN 07-538

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
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DRAWN	JS	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3805	SHEET 1 OF 8
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	WEARPLATE ASSY	NTS
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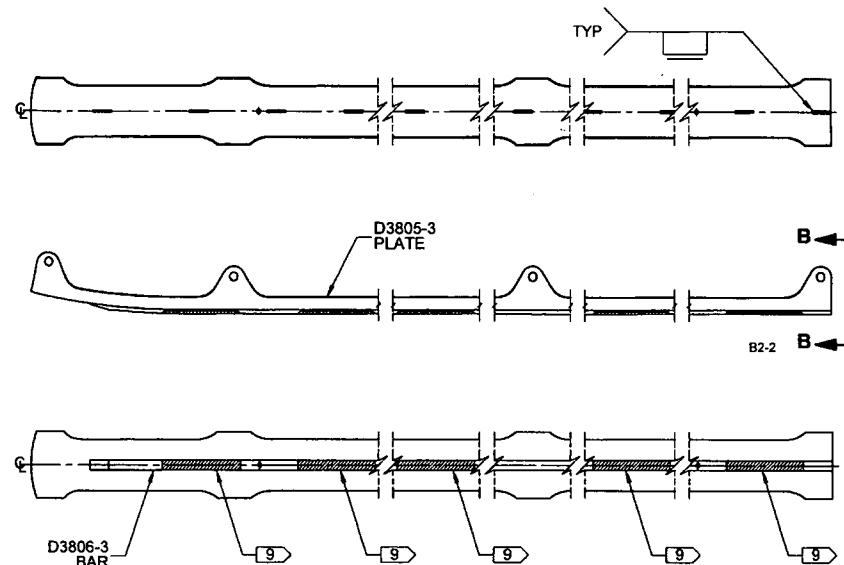
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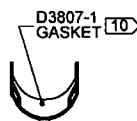
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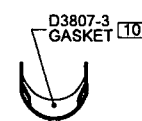
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



VIEW A-A C5-2



VIEW B-B C1-2

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09-03-07

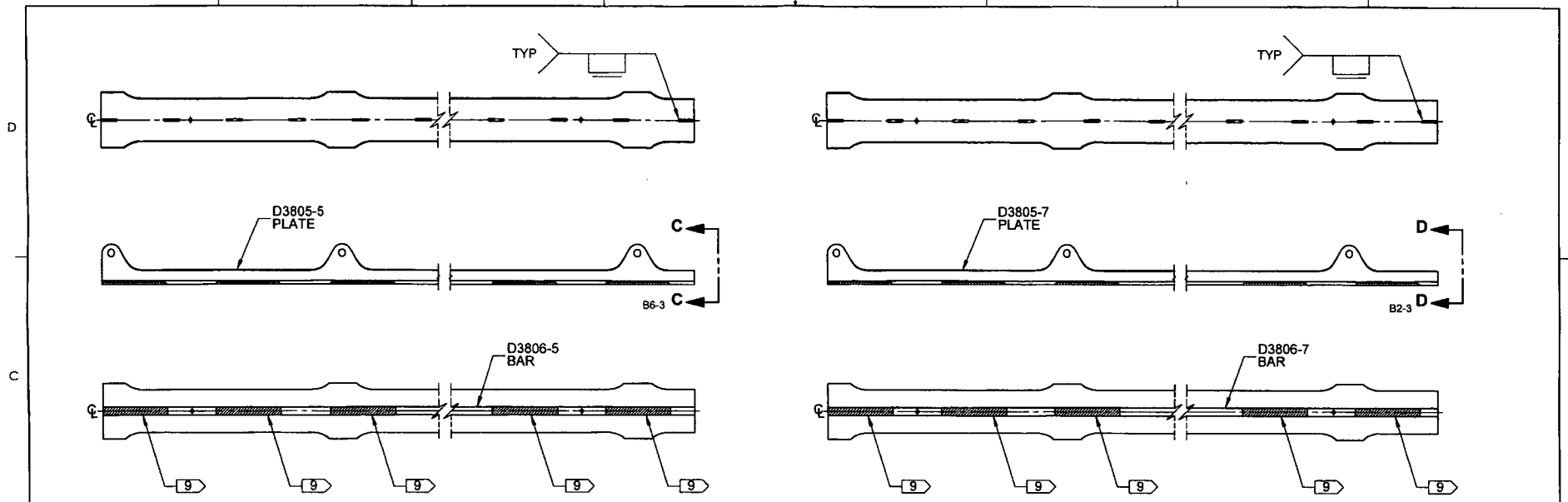
NO. 111111
WORK ORDER
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- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-041 = 3.79 lbs; D3805-043 = 4.36 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	JP	DART AEROSPACE USA, INC.	
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CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	JP	D3805	SHEET 2 OF 8
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEARPLATE ASSY	NTS
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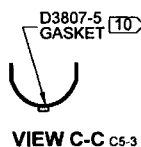
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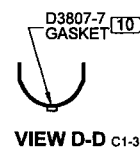


D3805-045 AFT WEARPLATE ASSY.

D3805-047 AFT WEARPLATE ASSY.



VIEW C-C C5-3



VIEW D-D C1-3

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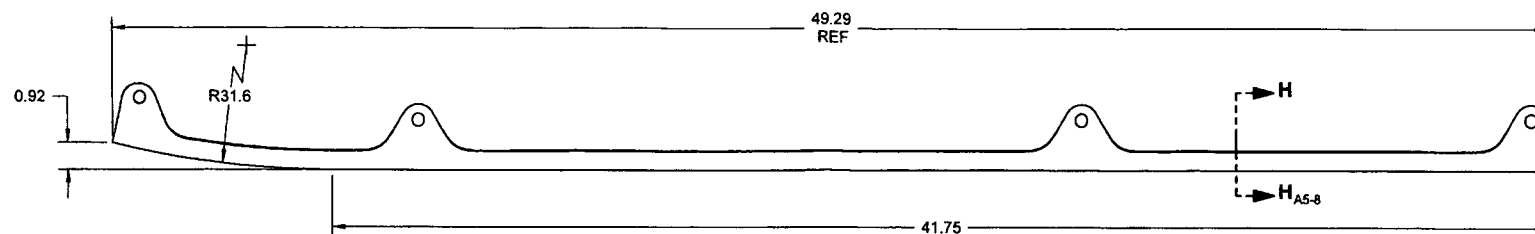
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- NOTES
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

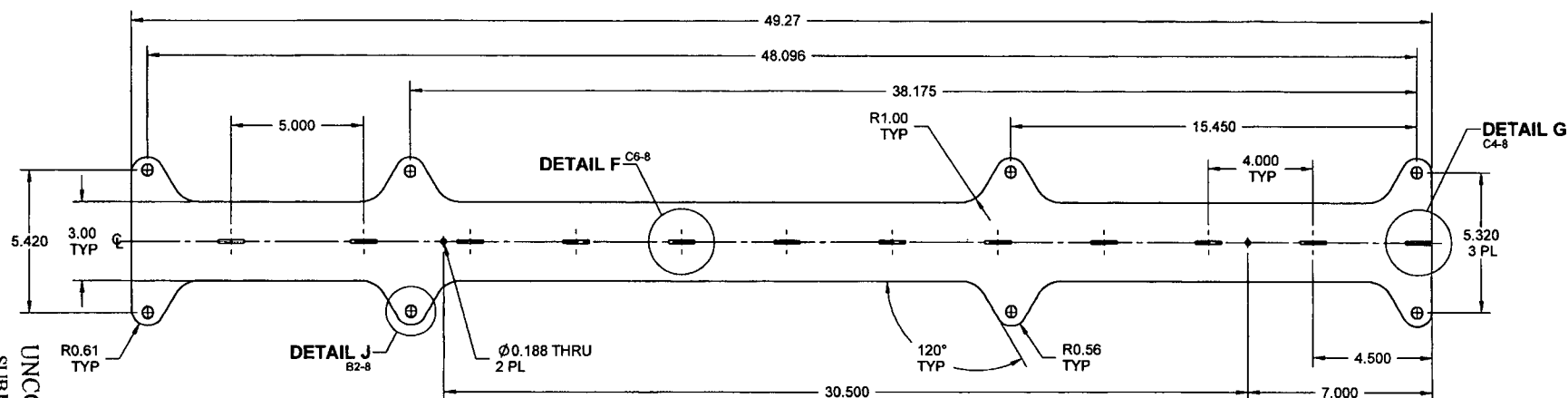
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MFG. APPR.	15	D3805	SHEET 3 OF 8
APPROVED	15	TITLE	SCALE
DE APPR.	15	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1



D3805-3 PLATE
(MAKE FROM D3805-3F)



D3805-3F PLATE

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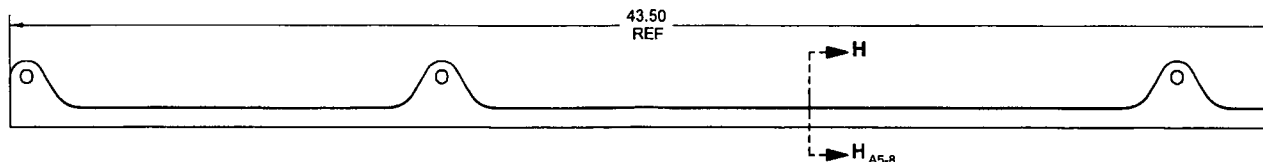
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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.37 lbs

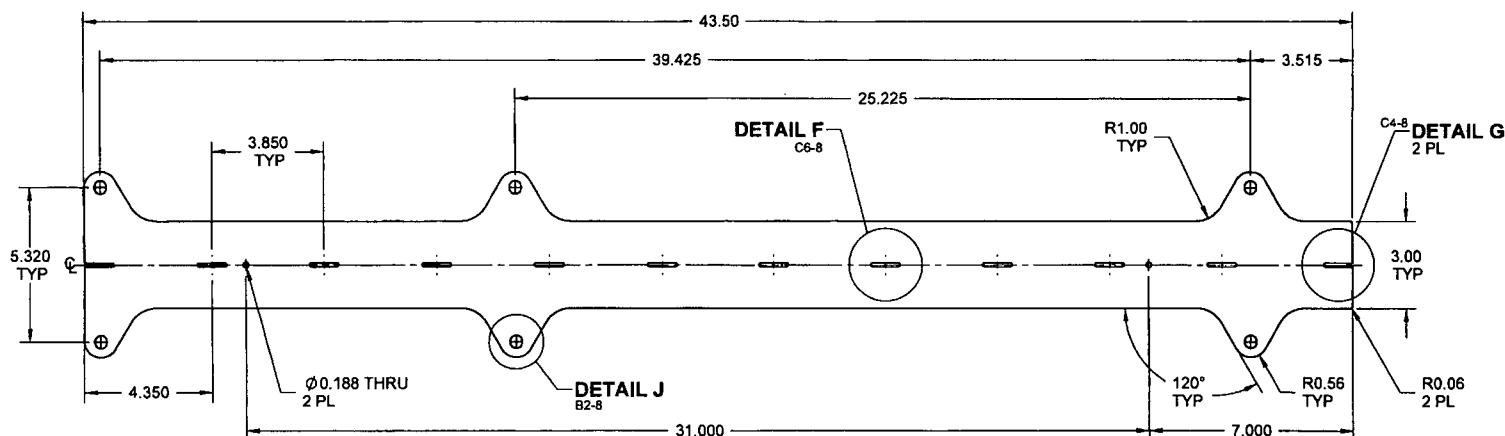
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DRAWN	145	PORT HADLOCK, WA	
CHECKED	145	DRAWING NO.	REV. A
MFG. APPR.	142	D3805	SHEET 5 OF 8
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D3805-5 PLATE
(MAKE FROM D3805-5F)



D3805-5F PLATE

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40 04 03 03

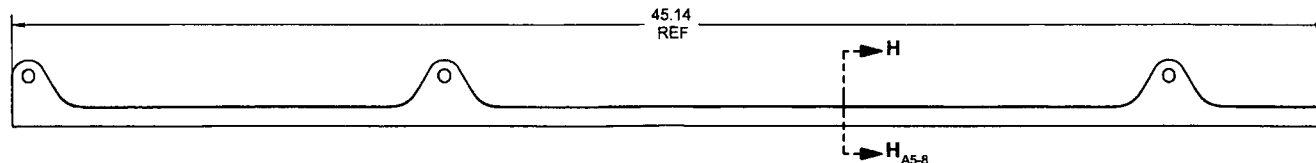
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- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.06 lbs

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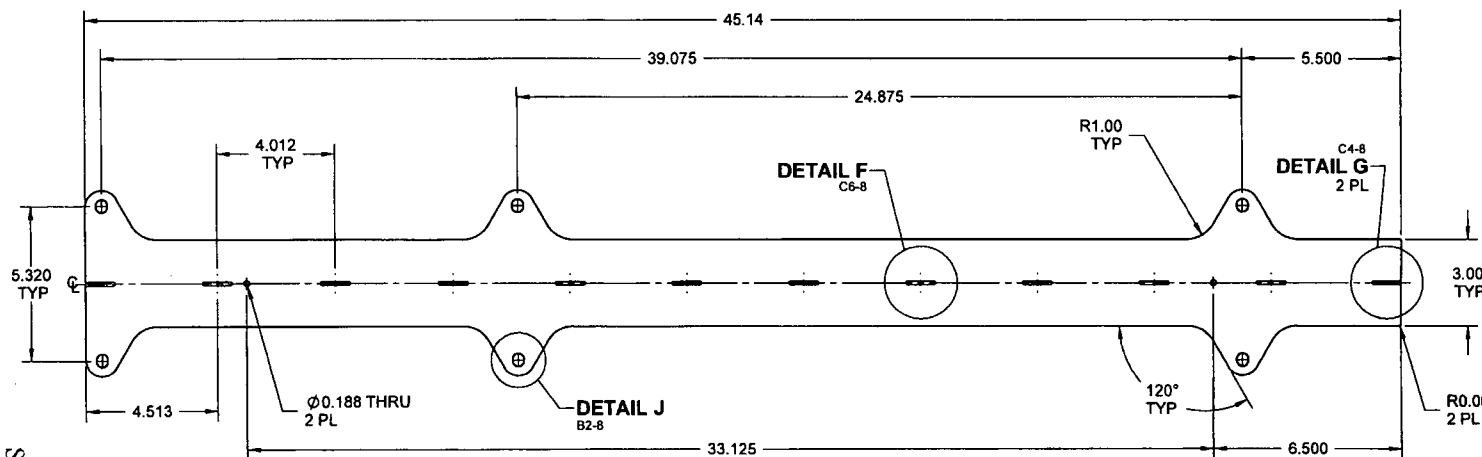
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D3805-7 PLATE
(MAKE FROM D3805-7F)



D3805-7F PLATE

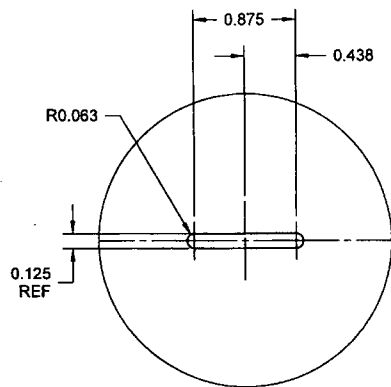
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09.03.07

- NOTES:**
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18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.13 lbs

WORK ORDER
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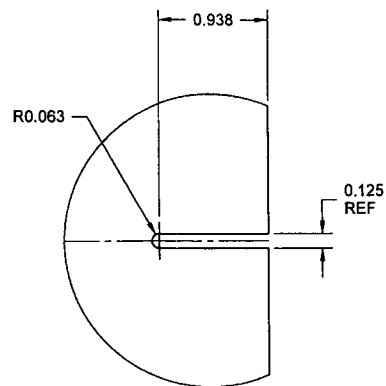
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MFG. APPR.	ls	D3805	SHEET 7 OF 8
APPROVED	ls	TITLE	SCALE
DE APPR.	ls	WEARPLATE ASSY	NTS
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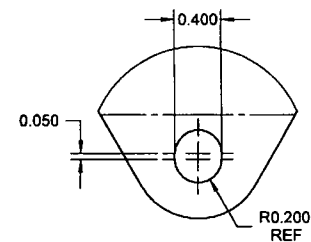
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



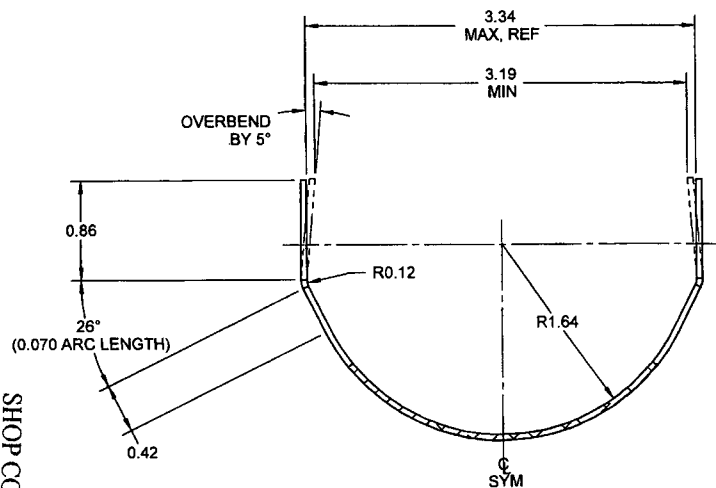
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

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909.03.03

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DRAWN	JP	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3805	SHEET 8 OF 8
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEARPLATE ASSY	
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